



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

009426

D5407-041
Job Sheet 193262



Part No: D5407-041

Job Qty: 2 pcs

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No:

Due Date: 4/29/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG REV A SHEETS 1,4 IPP REV:A NEW ISSUE JLM 16.06.06 VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Bandsaw - 1	2 pcs	4/29/19	4/29/19	0.00	0.60	Bandsaw - 1		DAS 52 9-89	19/04/18
110	Conventional Mill - 1 - B4B	2 pcs	4/29/19	4/29/19	0.00	2.86	Conventional Mill - 1 - B4B		DAS 52 9-89	19/04/18
							Conventional Mill - 2 - B4B			
120	QC 2	2 pcs	4/29/19	4/29/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51		DAS 52 9-89	17/04/18
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			

ART

EROSPACE

Order No: S173634



05407 - 041

o: 193262

No/Batch: S173634

n:

Dr:

e:

ions: Various STC's

Darta Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K64 1K7

CANADA

TEL.: 1 813 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

Date: 04/19/19



Container No: S173634



Part: D5407-041

Job No: 193262

Serial No/Batch: S173634

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/18/19

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				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
130 QC 8	2 pcs	4/29/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
140 Handfinish - 1-1 Chemical-B4B	2 pcs	4/29/19	0.00 0.31	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	2 pcs	4/29/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	

				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	BL 19-4-88
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
160 Powdercoat - 1 White GI(A)- B4B 11151749.	2 pcs	4/29/19	0.00 0.08	Powdercoat - 1 - B4B	
Strip 3.30 out 3.30 Finish 4:00.				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BL 19-4-88
170 QC 3	2 pcs	4/29/19	0.00 0.00	Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	BL 19-4-88
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	DAS APR 24 2019 40 9-89
				QC 3 - 19	
180 Small Fab - 2 - B4B	2 pcs	4/29/19	0.00 1.12	Small Fab - 1 - B4B	DAS 58 APR 26 2019 9-89
				Small Fab - 2 - B4B	CR.
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
190 QC 5	2 pcs	4/29/19	0.00 0.00	QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	

				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
200 Packaging 3-1 - Stock - B4B				Packaging 3 - 1 - B4B	APR 26 2019
2				Packaging 3 - 2 - B4B	
pcs				Packaging 3 - 3 - B4B	
4/29/19				Packaging 3 - 4 - B4B	
0.00 0.00				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	APR 27 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA				QC 21 - SA - 21	
2				QC 21 - SA - 70	APR 23 2019
pcs				QC 21 - SA - 53	
4/29/19					
0.00 0.00					
Part Op 100 - (Bandsaw) Cut at 24,850'					
Descriptions: 110 - (Manufacture as per dwg)					
120 - (QC2- Inspect parts off machine FAI/FAIB)					
130 - (QC8- Inspect parts - second check)					
140 - (Chemical Conversion Coat per QSI005 4.1)					
150 - (QC7-Inspect Chemical Conversion Coat)					
160 - (White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum)					
170 - (QC3- Inspect Part Finish)					
180 - (Small Fab)					
190 - (QC5- Inspect part completeness to step on W/O)					
200 - (Identify as per dwg & Stock Location:_____)					
210 - (QC21- Final Inspection - Work Order Release)					

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X00.750	6061-T6 Bar .750 X .750	4.1600 ft (2.08 ea)	100-Bandsaw - 1	5172189
AN3-12A	Bolt ST349	2 Ea (1 ea)	180-Small Fab - 2 - B4B	5133167
AN3-13A	Bolt ST349	2 Ea (1 ea)	180-Small Fab - 2 - B4B	5098032
D2690-6	Lanyard ST009	4 pcs (2 ea)	180-Small Fab - 2 - B4B	5166738
D5406-1	Connector	4 pcs (2 ea)	180-Small Fab - 2 - B4B	5175271
MS17984-C409	Pin, Quick Release ST315	2 Ea (1 ea)	180-Small Fab - 2 - B4B	5173053
MS17984-C508	Pin, Quick Release ST314	2 Ea (1 ea)	180-Small Fab - 2 - B4B	5157462
MS21042L3	Nut ST305	6 Ea (3 ea)	180-Small Fab - 2 - B4B	5094554
MS27039-1-20	Screw ST280	2 Ea (1 ea)	180-Small Fab - 2 - B4B	5162884
NAS1149D0363J	Washer ST264	16 Ea (8 ea)	180-Small Fab - 2 - B4B	

MAT
used
4.15'

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.750X00.750	4	17	0
180-Small Fab - 2 - B4B	AN3-12A	2	260	0
	AN3-13A	2	44	0
	D2690-6	4	42	0
	D5406-1	4	0	0
	MS17984-C409	2	11	0
	MS17984-C508	2	3	0
	MS21042L3	6	3,617	0
	MS27039-1-20	2	64	0
	NAS1149D0363J	16	1,446	0

Part Specifications				
Specifications could not be found.				

MD begin 2019

Entered: _____ Date: _____

NCR No. 19-7208

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐



Job: <u>193262</u>		DISPOSITION		DEPARTMENT/PROCESS				Route update only ☐							
Part No. <u>D5407-1</u>		Rework ☐ Scrap ☐ Use-as-is ☒		Skid-tube ☐ Machining ☒ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date: <u>19/4/18</u>		Sequence #: <u>110</u>		QTY Affected: <u>2</u>		MRB (QS1042) <u>125P</u> <u>17</u> <u>19/4/18</u>									
Description Work Order Deviation				Disposition											
Part is 0.749x0.749, below tolerance by 0.001.				Acceptable. Margins of SR-D205-941-2 are large and unaffected by 0.001 0.2% reduction in surface preparation <u>19/4/18</u>											
Root Cause				Completed By <u>19/4/18</u> Lead hand / Supervisor <u>B. 19-04-20</u>											
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				QC / QA Coordinator <u>DAS 68 9-89</u> <u>APR 21 2019</u>											
Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			

